

Date: Monday, 5/14/2007 2:00:16 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32344	
Estimate Number : 12679	
P.O. Number : <i>PIA</i>	Part Number : D35701
This Issue : 5/14/2007 S.O. No. : <i>PIA</i>	Drawing Number : D3570 REV <i>5</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>PIA</i>	Drawing Revision : B
Previous Run : 31866	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/15/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 07-01-30 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty: 0.0746 sf(s)/Unit Total: 1.4910 sf(s)

6061-T6 .125 Sheet

Batch: *M103156*

Grain must be Along 4.63**

M 07 05 15

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: *B*

Prog Rev: *B*

M 07 05 15

(20)

2-Deburr if necessary

MF - 07-05-22

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 07 05 15

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

070515 (20) counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

(40) ->

1-Form as per Dwg D3570 Using DT8945

FF 07-08-02

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: HA Date: 07.08.13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief-Eng.	Action Description Chief Eng	Sign & Date			
07/08/12	4 S.2	2 parts scrap dim 0.365 was found to be under the tol. R.C. Hammer		Scrap and Destroy No Reverse	FF 07/08/12	En 07/08/12	N/A	En 07/08/12

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 2:00:16 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32344

Part Number: D35701

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 07-08-02 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/02 (18)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 07/08/10

(18)

8.0

POWDER COATING

POWDER COATING



M 104846



(18X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 07/08/11

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Counted
07/08/13 (19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

07/08/13 (19)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.13

Job Completion



C 207/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

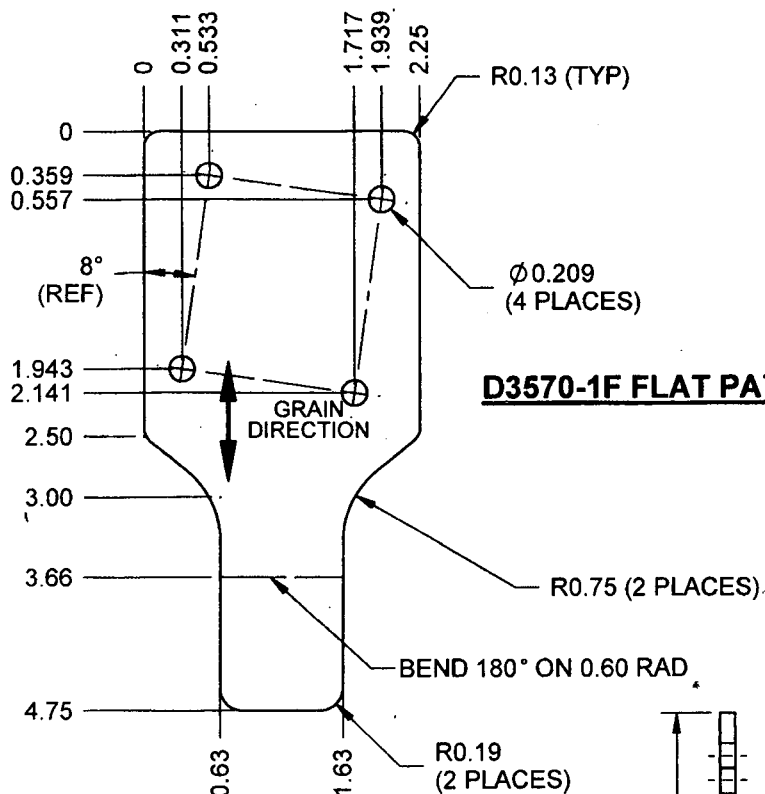
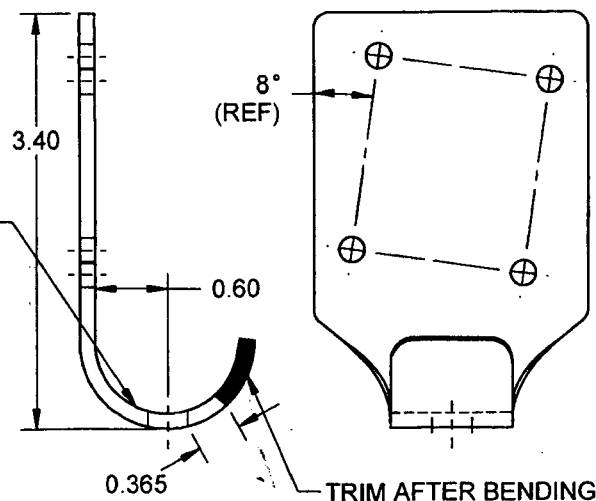
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET		SCALE 2:3
REV	DATE	DESCRIPTION	
A	07.02.07	NEW ISSUE	
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50	
C	07.06.01	UPDATE DIMS FOR CLARITY	

**D3570-1F FLAT PATTERN****RELEASED**07.06.04 *H**W/032344***D3570-1 BRACKET SHOWN**
(MAKE FROM D3570-1F)**D3570-2 BRACKET OPPOSITE**
(MAKE FROM D3570-1F)**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1/-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 32344
Description: Beepow D3570 bracket		Part Number: D3570-1
Inspection Dwg: 3570 Rev: B C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.209$	+0.005-0.001	0.209	✓		VEN	
B 2.25	+/- 0.030	2.254	✓		VEN	
C 4.75	+/- 0.030	4.758	✓		VEN	
D $\phi 0.359$	+/- 0.010	0.362	✓		VEN	
E 0.557	+/- 0.010	0.558	✓		VEN	
F 1.943	+/- 0.010	1.943	✓		VEN	
G 2.141	+/- 0.010	2.146	✓		VEN	
H 0.533	+/- 0.010	0.535	✓		VEN	
I 1.939	+/- 0.010	1.943	✓		VEN	
J 0.311	+/- 0.010	0.313	✓		VEN	
K 1.717	+/- 0.010	1.720	✓			
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>mm. mm</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 05 15	Date: 07 05 15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	